

Date: Monday, 7/9/2007 11:47:35 AM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG
Job Number : 33376	
Estimate Number : 11261	
P.O. Number :	Part Number : D34143
This Issue : 7/9/2007 S.O. No. :	Drawing Number : D3414
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 32516	Material :
Written By :	Due Date : 7/23/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>40</i> Um: Each
Comment : Est A 05:09:13 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304B0500X2500	304 BAR
-----	----------------	---------



Comment: Qty.: 0.1969 f(s)/Unit Total : 5.9063 f(s)  
304 BAR  
Material: 304/316 SS Bar  
(M304B0.500x02.500)  
Identify for D3414-3  
Batch: *M18929*

*J.L 08/01/03*

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
Cut blanks: 2.50" x 0.500" x 2.250" long

*J.L 08/01/03*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
Machine as per Folio FA569 and Dwg D3414  
Identify as D3414-3Dwg Rev \_\_\_\_ Folio Rev \_\_\_\_

*Issue PD 5358 machine per drwg D3414 Rev A*

*C208101104 (40)*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*Receive & inspect for transit damage ensure C/C attached*

*C208101118*

*(40)*

5.0	QC5	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

*Inspect level 5*

*5 08/01/21 (440)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

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Drawing Name: LUG

Job Number: 33376

Part Number: D34143

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Pat

*08/01/21*

*(90)*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



*08.01.22*

*[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*u 08.01.22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

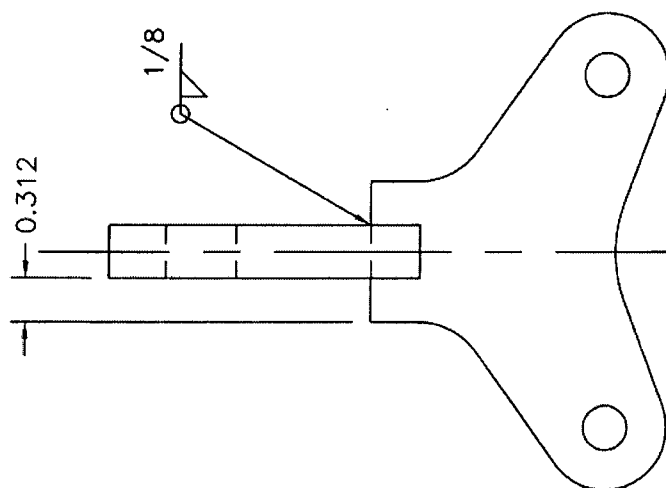
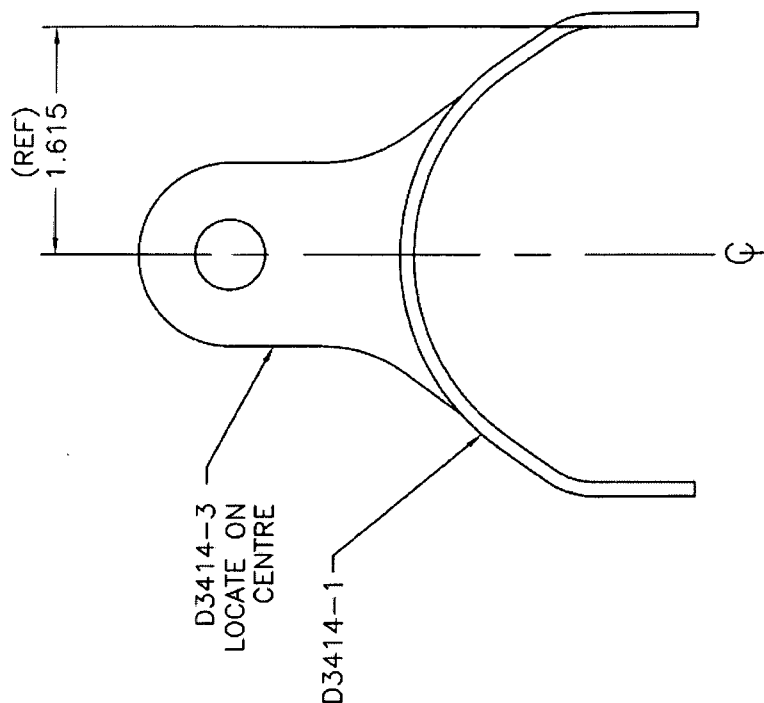
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3414	REV. A SHEET 1 OF 3
DATE 05.03.16		TITLE LUG ASSEMBLY	SCALE NTS
A	05.03.16	NEW ISSUE	

RELEASED  
05-09-06 *[Signature]*



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NO **33376**

**D3414-041 LUG ASSEMBLY**

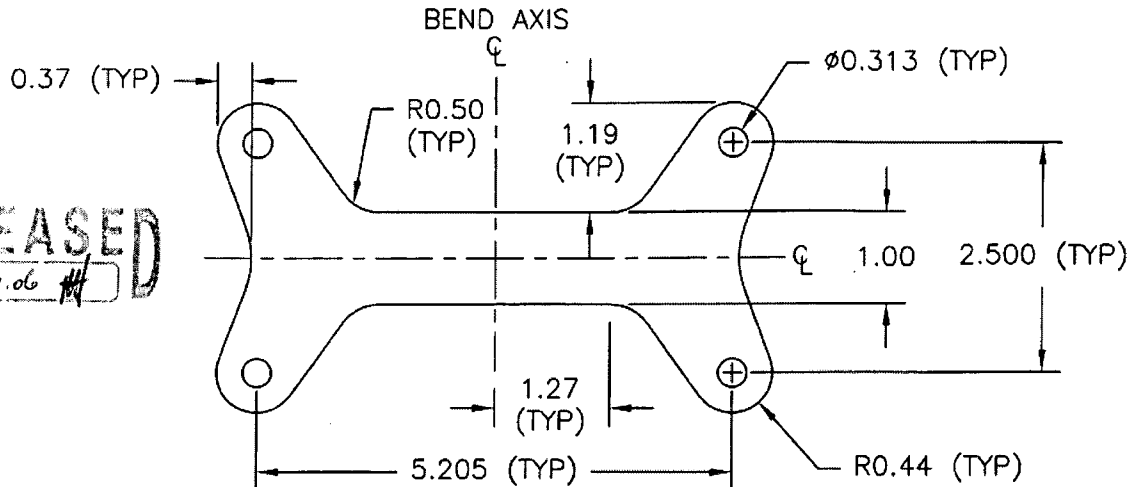
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRIC ABOUT CENTERLINE

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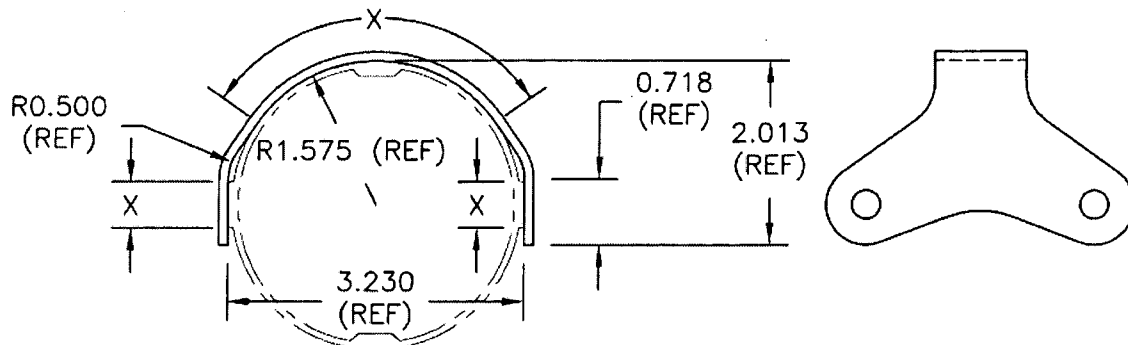
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DATE 05.03.16	TITLE LUG ASSEMBLY		SCALE 1:2

RELEASED  
05.09.06 *[Signature]***D3414-1 FLAT PATTERN**

SYMMETRICAL ABOUT BOTH CENTRE-LINES (CL)

**D3414-1 BEND DETAIL**

D3414-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

**D3414-1 LUG BRACKET**

- 1) MATERIAL: AISI 304/316 SS SHEET 0.100 THICK (12 GAUGE, REF DART SPEC M304S12GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

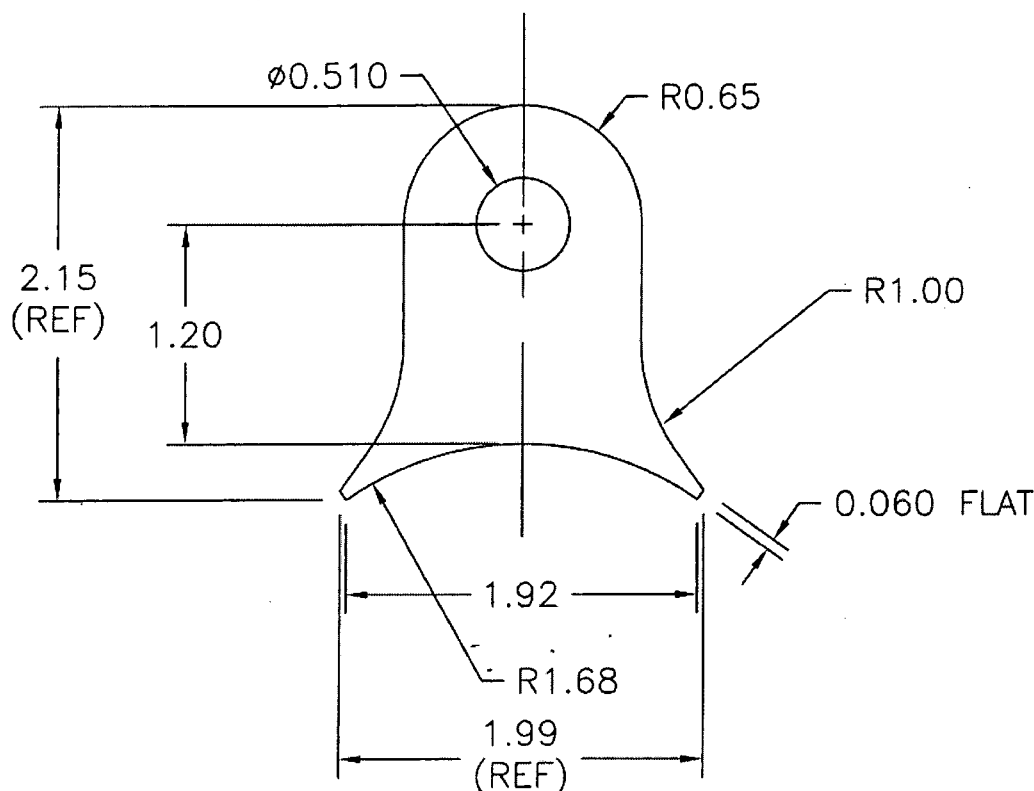
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DATE 05.03.16		TITLE LUG ASSEMBLY	SCALE 1:1

**RELEASED**  
05-07-06 [Signature]**D3414-3 LUG**

- 1) MATERIAL: AISI 304/316 SS PLATE 0.375 THICK (REF DART SPEC. M304S)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
40	D3414-3	Lug B33376	P5358
MATERIAL: supplied by DART M304B0500X02.500 M 18929			
10	D3404-1	Lug B35810	P5358
30	D3404-1	Lug B34849	P5358
MATERIAL: supplied by DART M304B0750X02500 M 105837			

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

  
Shigi Walz

Vankleek Hill, January 18, 2008